

Work Order ID 152696

152696

Page 1

Item ID: D4038-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angle Assy Fwd RH

Start Date: 11/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/9/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 2mDate: 11/11/14

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4038

E

100

Pick Kit

0.00

100

Packaging

Memo

0.03

Packaging

DAS
6
9-89

NOV 11 2016

110

110

Small Fab

Memo

0.00

0.06

Small Fab

Assemble as per dwg

1

FF

NOV 24 2016

120

120

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

send for test fit
do not paint - see StanDAS
38
9-89

NOV 24 2016

POSITIVE RECALL

EFFECTIVE 11/11/14 AUTH 2mRELEASED 9 DATE 12-01-24

0-89

PTD

DQA: *Amel* Date: 2017-02-16
QA Closed: *Rah* Date: FEB 15 2017

Date: 2017-02-16

QA Closed: 

Date: FEB 15 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: <u>152696</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>D4038-042</u>		Rework ☒		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. <u>17-6282</u>		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☒	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date: <u>17-01-24</u>		Step #: <u>120</u>		QTY Effective: <u>(1)</u>				MRB (QSI042) Approval			
								DAS 9 9-89 <u>17-01-24</u>			
Description Work Order Deviation				Disposition				Completed By			
Part use for test f.t. damage found from installation				Remove D4038.6/D4038-10 buff out marking abrade continue & work from seq 110 add new hardware				BEB 2017 17-02-02			
								Lead hand / Supervisor Approval Verification			
								PD 17-02-03			
								QC / QA Coordinator Approval			
								PD 17-02-03			
Root Cause				FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	
Material ☐	☒	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☒	Finish	
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :							
Misidentified ☐	☐	Past Due	☐								

Work Order ID 152696

Friday, November 04, 2016 1:13:51 PM

152696

Page 2

Item ID: D4038-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Angle Assy Fwd RH
Start Date: 11/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/9/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
121 *121* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo ***MASK INTERIOR OF BLOCKS AND MASK ALL HOLES WITHOUT BOLTS*** START TIME: 10:05 OVEN TEMPERATURE: 320° FINISH TIME: 10:35	0.00 0.01				1	0	17-02-2	DAS 34 9-89
122 *122* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			DAS 38 9-89 FEB 02 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: ST Memo	0.00 0.00				1			DAS 21 9-89 FEB 03 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
0-08 3A 0-08								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
140 QC	Memo	0.02							
Quality Control									

DAS
21
9-89

FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 152696

152696

Parent Item: D4038-042

D4038-042

Parent Item Name: Angle Assy Fwd RH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-04-21 JLM VERIFIED BY:EC IPP
Rev:B 11.01.31 as per dwg rev.c DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4038-2		Manufactured	No			100	Each	2.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4038-2

Angle, Fwd, RH

NOV 08 2016

Location

Loc Qty

Loc Code

ST513

2

144240

2

D4038-6		Manufactured	No			100	Each	1.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4038-6

Block

NOV 08 2016

Location

Loc Qty

Loc Code

ST072

1

135007

1

D4038-10		Manufactured	No			100	Each	0.0000	1	1			
----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4038-10

Block

DAS
30
9-89

NOV 24 2016

AN3-14A		Purchased	No			100	Each	122.0000	2	2			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

AN3-14A

Bolt

NOV 08 2016

Location

Loc Qty

Loc Code

over003

80

m134852

0

m135600

30

m135966

50

ST349

42

m134852

3

m135056

39

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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Page 2

Work Order ID: 152696

152696

Parent Item: D4038-042

D4038-042

Parent Item Name: Angle Assy Fwd RH

Start Date: 11/7/2016

Required Date: 11/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,665.000

2

2

MS21042L3

Nut

NOV 08 2016 DAS

6
9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

216

m134360

108

m135135

108

OVER007

600

m135945

600

ST303

842

m135530

239

m135600

3

m135767

600

NAS1149D0363J

Purchased

No

100

Each

1,172.000

4

4

NAS1149D0363J

Washer

NOV 08 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

336

m134055

336

ST263

836

m135864

836

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

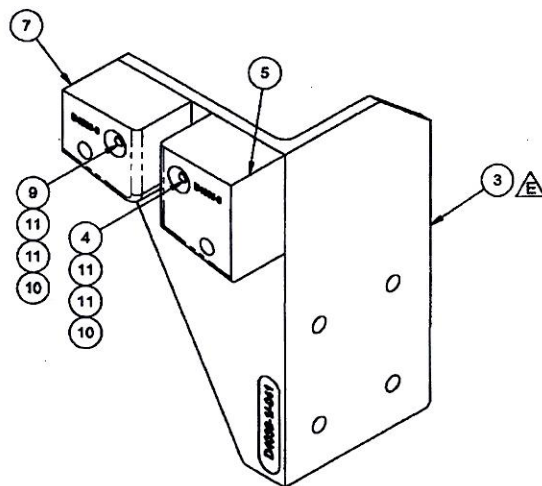
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D4038-041	ANGLE ASSEMBLY, FWD, LH
2		X	D4038-042	ANGLE ASSEMBLY, FWD, RH
3	1		D4038-1	ANGLE, FWD, LH
4		1	D4038-2	ANGLE, FWD, RH
5	1		D4038-5	BLOCK
6		1	D4038-6	BLOCK
7	1		D4038-9	BLOCK
8		1	D4038-10	BLOCK
9	2	2	AN3-14A	BOLT
10	2	2	MS21042L3	NUT
11	4	4	NAS1149D0363J	WASHER (AN960JD10)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152696

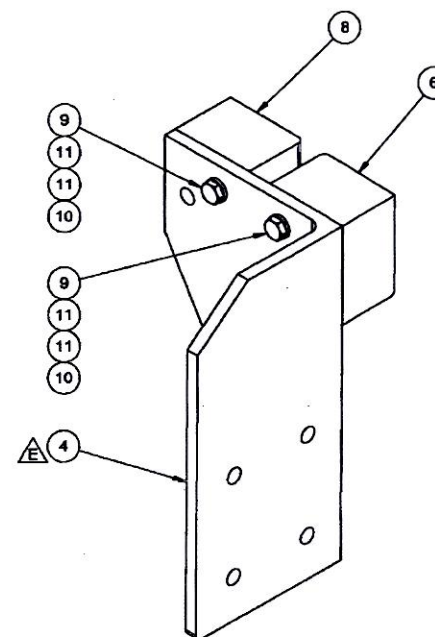
Em 16/11/4.



D4038-041 ANGLE ASSEMBLY, FWD, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041 - 1.75 lbs
-042 - 1.74 lbs



D4038-042 ANGLE ASSEMBLY, FWD, RH

RELEASED
2011-04-21
JMB

E	1.19 X 1.00 CHAMFER WAS R1.00. REF: NCR11-543.	MB	11.04.11
D	REVISED D4038-7/8/11/12 AS FOLLOWS: 1.87 WAS 1.73 (C7-9); 2.14 WAS 2.00 (C4-9); 2.13 WAS 2.00 (C7-10); 1.86 WAS 1.73 (C4-10); 1.52 WAS 1.38 (C7-13); 1.79 WAS 1.85 (C4-13); 1.77 WAS 1.85 (C7-14); 1.48 WAS 1.38 (C4-14). REASON: NCR11-458.	MB	11.03.03
C	REVISED D4038-3/4 AS FOLLOWS: 0.589 WAS 0.714 (B2-5, B4-6); D4038-043/044 ARE AFFECTED. REASON: NCR11-399.	MB	11.01.20
B	REVISED DIMENSIONS ALL SHEETS, ADD Ø0.316 HOLES IN -1/2-3/4 PARTS, ADD RADIUS TO -1/2-3/4 PARTS	HS	10.01.05
A	NEW ISSUE	HS	08.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.04.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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